

Work Order ID 99488

99488

Page 1

April 10, 2013 10:07:26 AM

Item ID: D3322-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Pod Assembly

Start Date: 4/10/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/12/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: C2 Date: 13/04/10 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Work Center ID	Description	Quantity	Unit Cost	Total Cost	Reject Number	Comp
----------------	-------------	----------	-----------	------------	---------------	------

Draw Nbr	Revision Nbr
----------	--------------

D2202	REV G
-------	-------

D3322	Rev A
-------	-------

JB

100 PURCHASING 0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 195410

Description:

D2202-1 Pod Lid D2202-5 Pod Base

Supplier: Delastek

Copy of Certificate of Conformity and Process sheet from Delastek is required

SHIP TO DELASTEK QTY (1) D3048-1

QTY (3) D3001-1

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo

Ensure certificate of conformity and process sheet from Delastek is attached

PL 13-04-10

PL 13/12 (1)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---	---	---	---

Work Order ID 99488

99488

Page 2

April 10, 2013 10:07:26 AM

Item ID: D3322-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Pod Assembly
 Start Date: 4/10/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 4/12/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	In p. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo Visual inspection. Check for void spot and pins. Check over all dimensions as per Dwg D2202.	0.00 0.00				①	②	13-10-04	
130 *130* Small Fab Small Fab	Small Fab Memo Assemble as per Dwg D2694 & D3322	0.00 0.00				①	②	13-10-04	
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1		13-10-04	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Work Order ID 99488

99488

Page 3

April 10, 2013 10:07:26 AM

Item ID: D3322-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pod Assembly
 Start Date: 4/10/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/12/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID:	Operation	Set Up	Tool ID	Tool #	Plan	Accept	Reject	Reject	Resp.
Work Center ID	Description	Run Hours			Code	Qty	Qty	Number	Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

PP

99487

13/10/17

MCS 13-10-07

MF

13-10-07

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---	---	---	---

Picklist Print

April 10, 2013 10:07:25 AM

Page 1

Work Order ID: 99488

Parent Item: D3322-041

Parent Item Name: Pod Assembly

Start Date: 4/10/13

Required Date: 4/12/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A04.11.12New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AD62ABS rivet		Purchased	No			130	Each	0.0000	38	125293	38		
AD64ABS Pop Rivets		Purchased	No			130	Each	189.0000	43	43	43		
				<u>Location</u>									
				123969		89							
				125147		100				125147			
AD66ABS POP RIVET		Purchased	No			130	Each	234.0000	2	2	2		
				<u>Location</u>									
				ST278		234							
				112784		234				112784			
AN4-5A Bolt		Purchased	No			130	Each	409.0000	19	19	19		
				<u>Location</u>									
				ST355		204							
				120562		204							
				ST514		205				120562			
				120562		205							
AN4-6A Bolt		Purchased	No			130	Each	2,289.0000	1	1	1		
				<u>Location</u>									
				ST514		2289							
				123355		2289							

13-09-25

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

April 10, 2013 10:07:26 AM

Page 2

Work Order ID: 99488

Parent Item: D3322-041

Parent Item Name: Pod Assembly

Start Date: 4/10/13

Required Date: 4/12/13

Start Qty: 1.00

Required Qty: 1.00

AN526C632R7
Screw

Purchased No

130 Each 147.0000

2

~~2073~~²

D4
336
88

Location

Loc Qty

Loc Code

ST345

147

112385

86

117317

61

112385

AN960JD416

NAS1149D0463J

Purchased No

130 Each 0.0000

21

126221

D4
336
88

Washer

D2202-1

Side Pod

D2202-5P

SIDE POD, BASE 350

D2204-9

Latch, Rubber

Purchased No

110 Each 0.0000

1

49488

DAS
32
88

Manufactured No

130 Each 24.0000

5

49488 D4
336
88

Location

Loc Qty

Loc Code

st239

24

85081

24

85081

D2429-041

Spring Clip Assembly

Manufactured No

130 Each 6.0000

1

1

D4
336
88

Location

Loc Qty

Loc Code

ST010

6

81895

6

81895

D2462

Seal

Manufactured No

130 f 509.4338

14.17

14.17

D4
336
88

13-09-25

Location

Loc Qty

Loc Code

ST403

509.4338

48530

13.7336

98802

495.7002

98802

April 10, 2013 10:07:26 AM

Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty.	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---	---	--

Picklist Print

April 10, 2013 10:07:26 AM

Page 3

Work Order ID: 99488

Parent Item: D3322-041

Parent Item Name: Pod Assembly

Start Date: 4/10/13

Required Date: 4/12/13

Start Qty: 1.00

Required Qty: 1.00

D2528-1
Backer Plate

Manufactured No

130 Each 25.0000

5 5

Location

Loc Qty

Loc Code

ST011

25

82334

21

85128

4

4x85128

D2528-3
Backer Plate

Manufactured No

130 Each 10.0000

4 4

Location

Loc Qty

Loc

ST011

10

65085

10

65085

D2569
Hinge

Manufactured No

130 Each 2.0000

1 1

Location

Loc Qty

Loc Code

CA

2

94308

2

13.10.03

D3001-1
Doublers

Manufactured No

110 Each 4.0000

3 3

Location

Loc Qty

Loc Code

ST178

4

63870

3

85393

1

B 99490x2

D3007-041
Strut

Manufactured No

130 Each 1.0000

1 1

Location

Loc Qty

Loc Code

ST259

1

84300

1

99639

D3048-1
Doublers

Manufactured No

110 Each 0.0000

1 1

13/04/12

B86098

April 10, 2013 10:07:26 AM

Shop Packet Print

Page 3

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

April 10, 2013 10:07:26 AM

Page 4

Work Order ID: 99488

Parent Item: D3322-041

Parent Item Name: Pod Assembly

Start Date: 4/10/13

Required Date: 4/12/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L06

Purchased

No

100

Each

303.0000

2

Nut

Location

Loc Qty

Loc Code

ST314

303

122441

3

124859

300

MS21042L4

Purchased

No

130

Each

2,149.0000

20

Nut

Location

Loc Qty

Loc Code

122452

306

8182

12

FP-001

12

8182

12

GA

2

121444

2

ST314

76

116548

4

119017

20

123248

36

123355

16

ST518

1741

124231

1741

NAS1149DN632J

Purchased

No

130

Each

175.0000

2

Washer

Location

Loc Qty

Loc Code

ST293

175

123900

175

April 10, 2013 10:07:26 AM

Shop Packet Print

Page 4

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816,
OR DERAKANE 470-36/411/510A40

FOAM: A500 CORE CELL,
OR DIVINYCELL,
OR AIREX,
0.38 THICK (3/8 FOAM)

FIBRE: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
5 oz PLAIN WEAVE KEVLAR (5 oz KEVLAR)

2) FINISH: INSIDE = PRIME PER DART QSI 005 4.2
OUTSIDE = WHITE GELCOAT #GEL 944W005

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: N/A

8) LAMINATE PER DART QSI 006
LAMINATION SCHEDULE PER THIS DRAWING.

9) PEEL PLY ALL SURFACES.

RELEASED
2010-10-28
MD

C213604/10
W10.99488

G	REFORMAT DRAWING TO CURRENT STANDARDS; D2202-101 WAS D2202-1 (ZN C5-2, A4-2); ADD 77.5 & 22.0 DIM. (ZN D4-3, C6-3); D2202-103 WAS D2202-5 (ZN C5-3, A4-3); ADD 2.00 MAX (ZN D3-4); INCORPORATED DEO 9217 & ADD D2202-5A-6 ON SHEET 5 PER PAR 09-034	RF	09.10.06
F	CHANGE LAYUP, DOUBLER, NOW DRILLED	CP	01.03.14
E	ADDED SECTIONS WITH LIP DIMS	KE	99.11.11
D	MOVED DOUBLERS, REMOVED HOLES	KE	98.11.09
C	REVISED DOUBLER/HOLES LOCATIONS	KE	97.07.04
B	ADD DOUBLERS AND HOLES	-	93.10.27
A	NEW ISSUE	-	93.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	97	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 1 OF 5
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

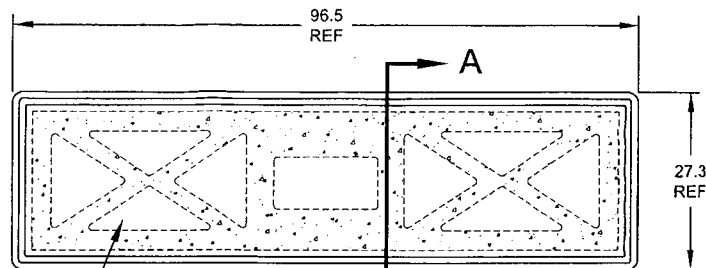
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

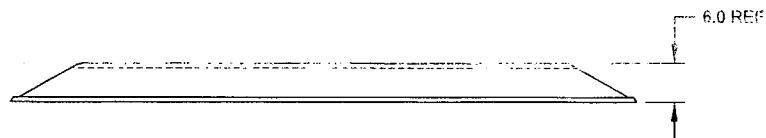
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---	---	---	---

SEE
DETAIL B
A6-2

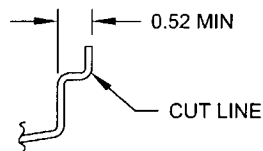
SECTION A-A C3-2



G
D2202-101 FOAM CORE,
MAKE FROM 3/8" FOAM. ROUTER PER DT6024



D2202-1 LID
(MOLD DT8002)



DETAIL B
SCALE 10X D6-2

MAIN LAYUP

9oz SATIN
9oz SATIN
5oz KEVLAR
D2202-101 FOAM CORE
5oz KEVLAR
9oz SATIN



RELEASED
2010-10-28

DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 2 OF 5
APPROVED	14	TITLE	SCALE
DE APPR.	14	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	<small>COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

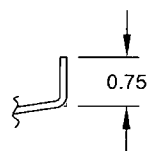
FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---	---	---	--	---

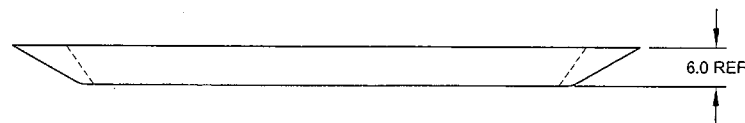
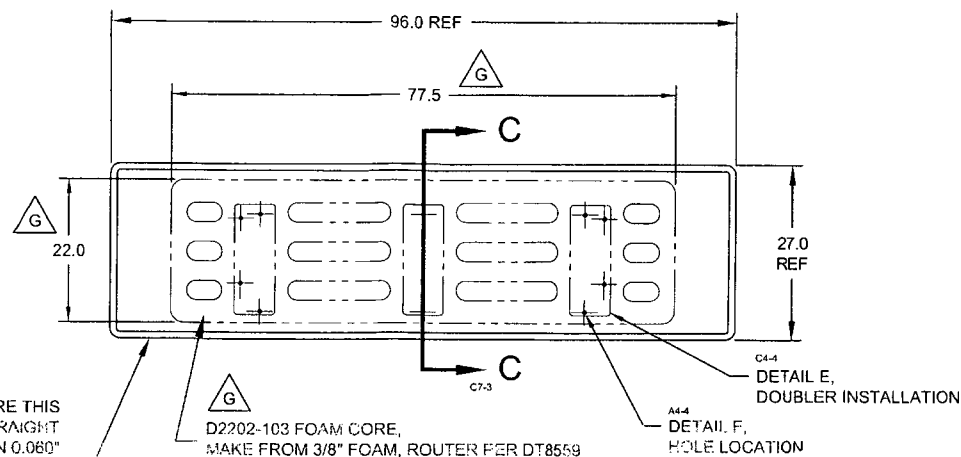
SEE
DETAIL D
B7-3

SECTION C-C C4-3

ENSURE THIS
EDGE IS STRAIGHT
WITHIN 0.060"
AFTER FORMING



DETAIL D
SCALE 10X
D7-3



D2202-3 BASE
(MOLD DT8002)

MAIN LAYUP

9oz SATIN
9oz SATIN
5oz KEVLAR
D2202-103 FOAM CORE
5oz KEVLAR
5oz KEVLAR
9oz SATIN



RELEASED
R 2010-10-28

DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	97	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 3 OF 5
APPROVED	102	TITLE	SCALE
DE APPR.	102	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	<small>COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

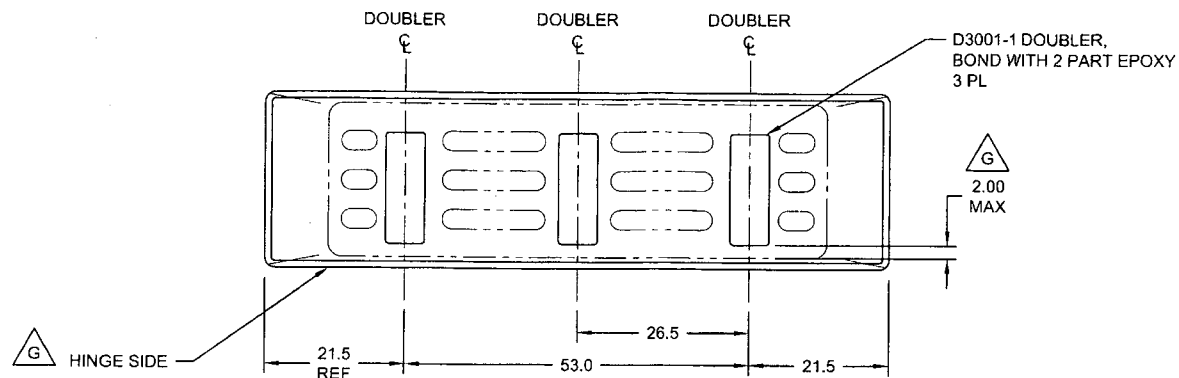
QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

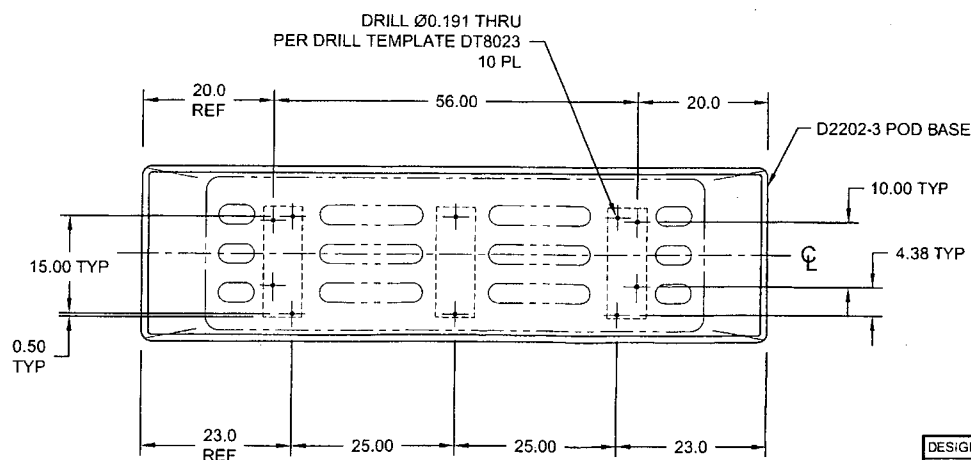
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---	---	---	--	---



DETAIL F: INSTALLATION OF D3001-1 DOUBLERS C3-3



DETAIL F: HOLE DRILLING C3-3
(AFTER DOUBLER INSTALLATION)

RELEASED
2010-10-28

DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 4 OF 5
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	<small>COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMER OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">Skid-tube <input type="checkbox"/></td> <td style="width: 33%;">Crosstube <input type="checkbox"/></td> <td style="width: 33%;">Water Jet <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> </tr> <tr> <td></td> <td></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td></td> <td></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td></td> <td></td> <td>Other <input type="checkbox"/></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			Engineering <input type="checkbox"/>			Quality <input type="checkbox"/>			Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>																					
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>																					
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>																					
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																					
		Engineering <input type="checkbox"/>																					
		Quality <input type="checkbox"/>																					
		Other <input type="checkbox"/>																					

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

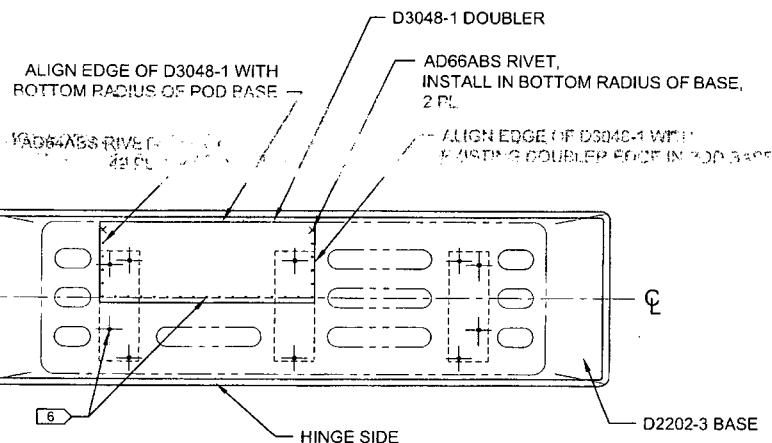
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

NOTES : TO MAKE A D2202-5/6 BASE (FOR D350-602-013-014) FROM A D2202-3 BASE

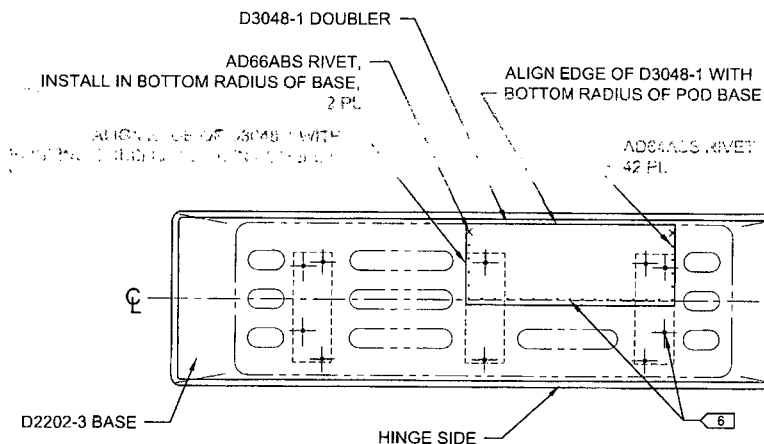
- 1) REMOVE FOAM IN AREA OF POD BASE WHERE D3048-1 DOUBLER WILL BE INSTALLED
- 2) FILL GAPS WITH 9oz SATIN AND RESIN PER DWG (APPROX. 3-4 LAYERS)
- 3) 2 LAYERS OF 9oz SATIN
- 4) BOND D3048-1 DOUBLER IN ORIENTATION SHOWN AND LET CURE
- 5) TRANSFER Ø0.125 HOLES FROM D3048-1 TO POD BASE. INSTALL DOUBLER WITH AD64ABS RIVETS (42) AND AD66ABS (2).
- 6) TRANSFER Ø0.191 HOLES FROM POD BASE TO D3048-1. SEAL HOLES WITH CYANOACRYLATE GLUE
- 7) TOUCH UP AFFECTED AREA WITH GREY PRIMER PER DWG
- 8) FILL CENTER OF THE AD RIVETS WITH RTV 732 TO SEAL

PART LIST:

QTY -5	QTY -6	PART NUMBER	DESCRIPTION
X		D2202-5	POD BASE
	X	D2202-6	POD BASE
1	1	D2202-3	BASE
1	1	D3048-1	DOUBLER
42	42	AD64ABS	RIVET
2	2	AD66ABS	RIVET
A/R	A/R	RTV	SEALANT



D2202-5 BASE: D3048-1 DOUBLER INSTALLATION
(MAKE FROM D2202-3 BASE)



D2202-6 BASE: D3048-1 DOUBLER INSTALLATION
(MAKE FROM D2202-3 BASE)

DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	90	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 5 OF 5
APPROVED	100	TITLE	SCALE
DE APPR.	100	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	<small>COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
--	---	---

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---	---	---	--	---



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AF</i>	APPROVED <i>AF</i>	DRAWING NO. D3322	REV. A SHEET 1 OF 1
DATE 04.09.26		TITLE POD ASSEMBLY	SCALE 1:15
A	04.09.26	NEW ISSUE	

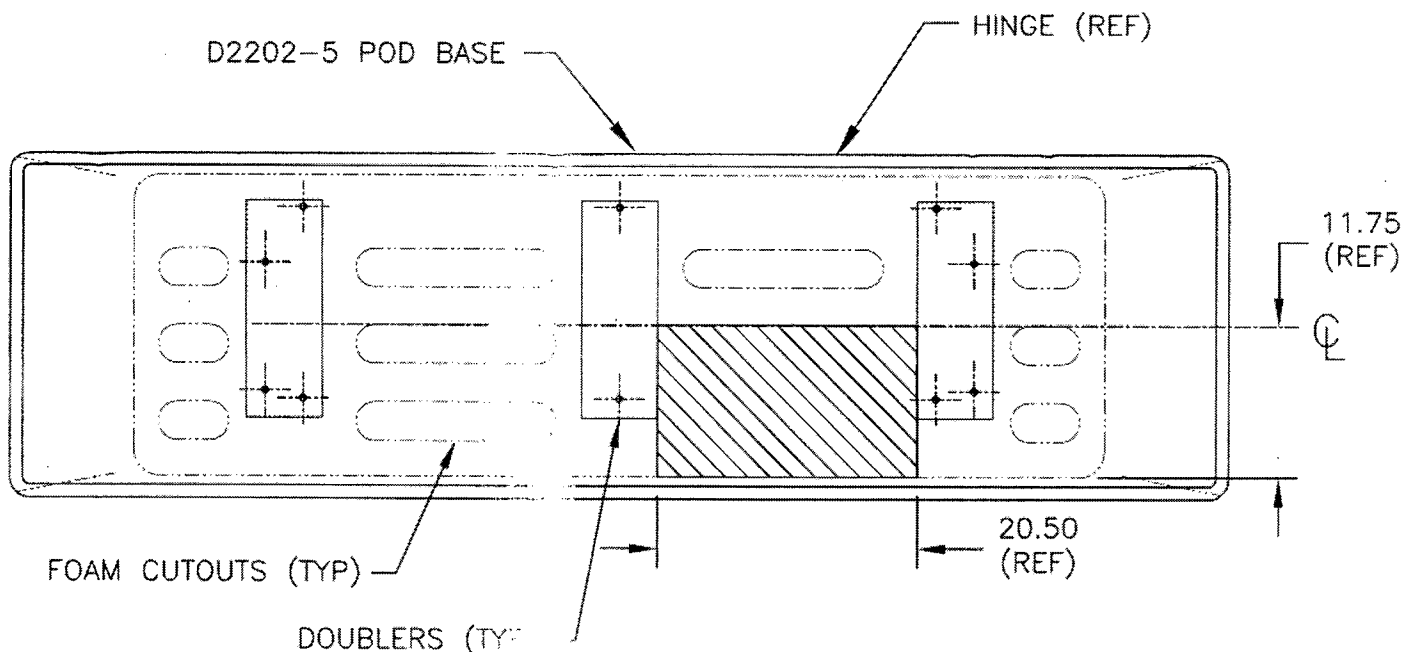
RELEASED
04.10.29 *AF*

D3322-041/-042 POD ASSEMBLY

- 1) THE D3322-041/-042 POD ASSEMBLIES ARE THE SAME AS THE D2694 POD ASSEMBLIES, EXCEPT THE D2202-3 POD BASE IS REPLACED WITH THE D2202-5 POD BASE

CA 13/04/16

W/O. 99488



D3322-041 POD ASSEMBLY (SHOWN)
D3322-042 POD ASSEMBLY (OPPOSITE)

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge _____ _____ _____	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19540

Purchase Order Date 4/10/13

PO Print Date 4/16/13

Page Number 1 of 1

Order From :

VU-DEL003

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

Contact Name

Vendor Phone 819 533 5788

Vendor Fax 819 533 3494

Vendor Account Nbr

Buyer

Brigitte Golden

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

REVISED

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
4/13/13

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Reg Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2202-1P	Side Pod Lid, 350	5/17/13 Yes	1.00 Each	Day & Ross coll	\$2,828.3800	\$2,828.38
Special Inst: AS PER DWG: D2202 REV: G B99488							
2	D2202-5P	SIDE POD, BASE 350	5/17/13 Yes	1.00 Each	Day & Ross coll	\$2,828.3800	\$2,828.38
Special Inst: AS PER DWG: D2202 REV: G B99488							

PO Total:

\$5,656.76

Change Nbr: 3

Change Date: 4/16/13

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required ☒ YES ☐ NO

Date: Mercredi, 2013-04-24 08:15:35
 L'élaborateur: Mario Chantal

Feuille de Procédé

Urgent



Client	: DART US DART AEROSPACE	Nom Dessin	: UTILITY POD LID
Numéro Job	: 51514	Numéro Article	: DKC134-0073
Numéro	: 4347	Numéro Dessin	: D2202
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2013-04-24	Révision dessin	: G
Prsht Rev.	: NC	Matériel	: Resine Darakane 470-36/411/510
Prem. fois	: - -	Date Dûe	: 2013-05-01
Job précédente	: 44975	Qté:	1 Ud UNITE
Écrit par	:		
Vérifié & Approuvé par	:		
Commentaires	: N° de Pièce Client: D2202-1		

Process Sheet Rév.: 03. Ajout de la IF134-0008 à la séquence 35.0.

Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
---------	------------	---------------

1.0	AAC1616	N° 83634, Frekote Loctite Wolo
-----	---------	--------------------------------

Comment	Qty.: 0.030 UNITE(s)/Unit	Total : 0.030 UNITE(s)
	N° 83634, Frekote Loctite Wolo	# de Lot: 1-37420-1

2.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Comment	Setup: 0.00Hrs/ Run: 0.0000Min	Total Run : 0.0000Hrs
----------------	--------------------------------	-----------------------

Faire la préparation du moule N° DT8002 selon IG 0009.

Date: 30/04/13 Sceau: 4440 CS 4463 SV

3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Comment	Qty.: 1.250 KILOGRAMME(s)/Unit	Total : 1.250 KILOGRAMME(s)
	Gel Coat Blanc N° Gel 944W005	N° de Lot: 1-39457-1

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Comment	Qty.: 0.0095 GALLON(s)/Unit	Total : 0.0095 GALLON(s)
	Catalyst N° DDM-9	N° de Lot: 1-27829-1

5.0	GEL COAT	Application du Gel Coat
-----	----------	-------------------------



Comment	Setup: 0.00Hrs/ Run: 0.0000Min	Total Run : 0.0000Hrs
----------------	--------------------------------	-----------------------

Appliquer le gel coat selon IG 0019.

Date: 30/04/13 Sceau: 4440 CS

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 51514

Nom Dessin: UTILITY POD LID
Numéro: DKC134-0073

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

6.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
-----	---------	---

Comment Qty.: 9.90 VERGE(s)/Unit Total : 9.90 VERGE(s)
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-32576-1

7.0	AAC1885	Tissu à délaminer Release ply B
-----	---------	---------------------------------

Comment Qty.: 9.16 VERGE(s)/Unit Total : 9.16 VERGE(s)
Tissu à délaminer Release ply B

de Lot: N/A

8.0	AAC1608	5oz plain weave Kevlar 50" wide roll
-----	---------	--------------------------------------

Comment Qty.: 6.60 VERGE(s)/Unit Total : 6.60 VERGE(s)
5oz plain weave Kevlar 50" wide roll

N° de Lot: 1-28178-1

9.0	AAC1887	Wrightlon 5200 Bleu P3
-----	---------	------------------------

Comment Qty.: 14.95 VERGE(s)/Unit Total : 14.95 VERGE(s)
Wrightlon 5200 Bleu P3

de Lot: N/A

10.0	AC0885	Feutre de drainage N° Airweave N 10
------	--------	-------------------------------------

Comment Qty.: 12.50 VERGE(s)/Unit Total : 12.50 VERGE(s)

11.0	AC0943	Stretchlon 200 poche à vide Vert
------	--------	----------------------------------

Comment Qty.: 42.63 PIED(s)/Unit Total : 42.63 PIED(s)

12.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
------	--------	-----------------------------------

Comment Qty.: 3.0000 ROULEAU(s)/Unit Total : 3.0000 ROULEAU(s)

13.0	TAILLAGE	Faire le taillage du matériel
------	----------	-------------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le taillage du matériel selon les Dimensions requises:

Un morceau pour recouvrir le fond du moule N° DT8002.

Deux morceaux pour couvrir les extrémités du moule N° DT8002.

Deux morceaux pour recouvrir les cotés du moule N° DT8002.

Faire cette opération pour les trois plis de 9 oz ainsi que pour les deux plis de 5 oz de Kevlar.

Tailler le matériel nécessaire pour la poche à vide (Faire 3 kits car il y aura trois baggings différents lors de la fabrication de cette pièce):

Peel Ply

Film Durisol P-3








Feutre de drainage 6m

Stretchlon 200












Coller une bande de ruban jaune tout le tour du Stretchlon 200, plier les différentes composantes des poches à vide et entreposer en attente des opérations de bagging.

Date: Mercredi, 2013-04-24 08:15:35
Utilisateur: Mario Chantal








Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	UTILITY POD LID
Numéro Job:	51514	Numéro	DKC134-0073
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
Date: <u>23/05/13</u> Sceau: <u>4432 G.B.</u>			
14.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-408-19-1</u>		
15.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
16.0	PREP-GENERAL	Préparation du matériel	
 			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Mélanger la quantité de résine désirée pour le laminage des trois premier plis du Pod Lid : 1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 Min. Date: <u>31/05/13</u> Sceau: <u>4440 CS 4433 JRC</u>		
17.0	LAMINAGE	Faire le laminage	
 			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le laminage des trois premiers plis de tissu (2 plis de 9 oz et 1 pli de 5 oz Kevlar) de la façon suivante: Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350 Promoté 75 Minutes, ensuite venir laminer un pli de 9 oz dans le fond du moule, suivre avec les deux extrémités et terminer avec les deux cotés. (Ajouter de la résine au besoin) Recommencer pour les deux autres plis. (un pli de 9 oz et un pli de 5 oz Kevlar) Date: <u>31/05/13</u> Sceau: <u>4440 CS 4433 JRC</u>		
18.0	BAGGING	Faire le bagging sur la pièce	
 			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la poche à vide selon IG 0012 Laisser sécher 4 heures minimum Date: <u>31/05/13</u> Sceau: <u>4440 CS 4433 JRC</u>		













Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	UTILITY POD LID
Numéro Job:	51514	Numéro	DKC134-0073
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
19.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-41438-1</u>		
20.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0135 GALLON(s)/Unit Total : 0.0135 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
21.0	DKC134-0022	D2202-101 Foam Core (Utility Pod Lid)	
Comment	Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) D2202-101 Foam Core (Utility Pod Lid) N° de Job: <u>52882</u>		
22.0	PREP-GENERAL	Préparation du matériel	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire un mélange de résine Derakane 411-350 Promoté 15 à 18 Minutes 1.5% de catalyst DDM-9 par quantité de résine. Date: <u>10/06/13</u> Sceau: 		
23.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Sceller le Foam Core N° DKC134-0022 selon IG 0105. Date: <u>10/06/13</u> Sceau: 		
24.0	AAC1611	Polybond B46F	
Comment	Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s) Polybond B46F N° de Lot: <u>1-38189-1</u>		
25.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire l'assemblage du Foam Core N° DKC134-0022 à l'aide du polybond 46F selon IG 0033. Date: <u>11/06/13</u> Sceau: <u>4440 CS</u>		
26.0	BAGGING	Faire le bagging sur la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la poche à vide selon IG 0012.		

Feuille de Procédé

Client: DART US DART AEROSPACE Numéro Job: 51514 Numéro Job: 	Nom Dessin: UTILITY POD LID Numéro: DKC134-0073
# Séq.: Machine ou Opération: Description :	
<p>Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.</p> <p>Heure début Curing: <u>2 PR</u> Heure Fin Curing: <u>2h15 PR</u> Date: <u>11/04/13</u> sceau: <u>4440 C5</u></p>	
27.0	AMB0212 Résine (411B7530) 411-350 promo. 75min.
Comment Qty.: 2.500 KILOGRAMME(s)/Unit Total: 2.500 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-41438-1</u>	
28.0	AMB0286 Catalyst N° DDM-9
Comment Qty.: 0.0845 GALLON(s)/Unit Total: 0.0845 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>	
29.0	PREP-GENERAL Préparation du matériel
 	
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs	
<p>Mélanger la quantité de résine désirée pour le laminage des deux derniers plis du Pod Base: 1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 minutes.</p> <p>Date: <u>12/06/13</u> Sceau:  <u>4440 C5</u></p>	
30.0	LAMINAGE Faire le laminage
 	
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs	
<p>Faire le laminage des deux dernier plis de tissu (1 plis de 5 oz Kevlar et 1 pli de 9 oz) de la façon suivante:</p> <p>Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350 Promoté 75 minutes, ensuite venir laminer un pli de 5 oz Kevlar dans le fond du moule, suivre avec les deux extrémités et terminer avec les deux cotés. (Ajouter de la résine au besoin)</p> <p>Recommencer pour le dernier plis. (un pli de 9 oz)</p> <p>Date: <u>12/06/13</u> Sceau:  <u>4440 C5</u></p>	

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	UTILITY POD LID
Numéro Job:	51514	Numéro	DKC134-0073
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
35.0	TRIMAGE	Trimage	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le trimage du Pod Lid selon la IF134-0008. Date: <u>18/06/13</u> Sceau:  <u>4460 R.L.</u>			
36.0	AAC1021	Dupont Primer N° 7704S	
Comment Qty.: 0.4300 UNITE(s)/Unit Total : 0.4300 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>1-39123-1</u>			
37.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1-40542-1</u>			
38.0	PRIMER	Application primer	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008 Date: <u>08-07-13</u> Sceau:  # Fiche de Mélange: <u>6437</u>			
39.0	FINITION	Finition Générale	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le sablage au grit 180 de la surface primé pour enlever les imperfections restantes. Date: <u>09-07-13</u> Sceau: <u>RL 4460</u>			
40.0	AAC1021	Dupont Primer N° 7704S	
Comment Qty.: 0.2167 UNITE(s)/Unit Total : 0.2167 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>1-39123-1</u>			
41.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>1-40542-1</u>			
42.0	PRIMER	Application primer	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008 Date: <u>10/07/13</u> Sceau:  # Fiche de Mélange: <u>6439</u>			

Date: Mercredi, 2013-04-24 08:15:36
Utilisateur: Mario Chantal

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	UTILITY POD LID
Numéro Job:	51514	Numéro	DKC134-0073

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

43.0	INSPEC FINAL	Inspection finale
------	--------------	-------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: 11 juillet 13 Sceau:



44.0	EMBAL / ENTREPO	Emballage & Entreposage
------	-----------------	-------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057

Date: 11 juillet 13 Sceau:

Date: Mercredi, 2013-04-24 08:15:55
Utilisateur: Mario Chantal

Feuille de Procédé

Urgent.

Client	: DART US DART AEROSPACE	Nom Dessin	: UTILITY POD BASE
Numéro Job	: 51515	Numéro Article	: DKC134-0075
Numéro	: 4345	Numéro Dessin	: D2202
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2013-04-24 No. :	Révision dessin	: G
Prsht Rev.	: NC	Matériel	: Resine Darakane 470-36/411/510
Prem. fois	: - - Type :	Date Dûe	: 2013-05-01 Qté: 1 Ud UNITE
Job précédente	: 44976		
Écrit par	:		
Vérifié & Approuvé par	:		
Commentaires	: N° de Pièce Client: D2202-5		

Process Sheet Rév.: 02 AAC1885 était AC0883,
AAC1887 était AC0884

Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
---------	------------	---------------

1.0	AAC1616	N° 83634, Frekote Loctite Wolo
-----	---------	--------------------------------

Comment Qty.: 0.030 UNITE(s)/Unit Total: 0.030 UNITE(s)
N° 83634, Frekote Loctite Wolo # de Lot: 1-37420-1

2.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation du moule DKO-0331 selon IF134-0011.

Date: 7/05/13 Sceau: 4440 CS

3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Comment Qty.: 1.250 KILOGRAMME(s)/Unit Total: 1.250 KILOGRAMME(s)
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-39457-1

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Comment Qty.: 0.0095 GALLON(s)/Unit Total: 0.0095 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27839-1

5.0	GEL COAT	Application du Gel Coat
-----	----------	-------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs




Appliquer le Gel Coat sur le moule selon IF134-0011.

Date: 21/06/13 Sceau:











Date: Mercredi, 2013-04-24 08:15:55
Utilisateur: Mario Chantal

Feuille de Procédé













Client:	DART US DART AEROSPACE		Nom Dessin:	UTILITY POD BASE	
Nuiséro Job:	51515		Numéro	DKC134-0075	
Numéro Job:					
# Séq.:	Machine ou Opération:	Description :			
6.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish			
Comment	Qty.: 9.90 VERGE(s)/Unit Total : 9.90 VERGE(s)		9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-39576-1		
7.0	AAC1885	Tissu à délaminer Release ply B			
Comment	Qty.: 9.16 VERGE(s)/Unit Total : 9.16 VERGE(s)		Tissu à délaminer Release ply B # de Lot: N/A		
8.0	AAC1608	5oz plain weave Kevlar 50" wide roll			
Comment	Qty.: 6.60 VERGE(s)/Unit Total : 6.60 VERGE(s)		5oz plain weave Kevlar 50" wide roll N° de Lot: 1-28178-1		
9.0	AAC1887	Wrightlon 5200 Bleu P3			
Comment	Qty.: 14.95 VERGE(s)/Unit Total : 14.95 VERGE(s)		Wrightlon 5200 Bleu P3 # de Lot: N/A		
10.0	AC0885	Feutre de drainage N° Airweave N 10			
Comment	Qty.: 12.50 VERGE(s)/Unit Total : 12.50 VERGE(s)				
11.0	AC0943	Stretchlon 200 poche à vide Vert			
Comment	Qty.: 42.63 PIED(s)/Unit Total : 42.63 PIED(s)				
12.0	AC0886	Ruban à gommer jaune #: T/AT-200Y			
Comment	Qty.: 3.0000 ROULEAU(s)/Unit Total : 3.0000 ROULEAU(s)				
13.0	AC1091	Film durisol # 3001792			
Comment	Qty.: 12.50 METRE CAR(s)/Unit Total : 12.50 METRE CAR(s)				
14.0	TAILLAGE	Faire le taillage du matériel			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs				
Faire le taillage du matériel et le matériel pour le Bagging selon IF 134-0011.					
Date: 26/04/13 Sceau: 4432 GB.					
15.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.			
Comment	Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s)		Résine (411B7530) 411-350 promo. 75min. N° de Lot: 411B7530 RL 1-41438-1		
16.0	AMB0286	Catalyst N° DDM-9			
Comment	Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s)		Catalyst N° DDM-9 N° de Lot: 1276 291		
17.0	LAMINAGE	Faire le laminage			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs				
Faire le laminage des tissus(verre et Kevlar) selon IF134-0011.					
Date: 26-06-13 Sceau: 4102 MT RL 41460					

Date: Mercredi, 2013-04-24 08:15:55
Utilisateur: Mario Chantal

Feuille de Procédé











Cliant:	DART US DART AEROSPACE	Nom Dessin:	UTILITY POD BASE
Numéro Job:	51515	Numéro	DKC134-0075
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
18.0	BAGGING	Faire le bagging sur la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Faire la poche à vide selon IG 0012.		
	Laisser sécher pendant 4 heures minimum.		
	Heure début Curing: <u>16:30</u> Heure Fin Curing: <u>8:00 am</u>		
	Date: <u>21-06-13</u> Sceau: <u>4102 NT RL 4460</u>		
19.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-41438-1</u>		
20.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0135 GALLON(s)/Unit Total : 0.0135 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
21.0	DKC134-0021	D2202-103 Foam Core (Utility pod Base)	
Comment	Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) D2202-103 Foam Core (Utility pod Base) N° de Job: <u>52883</u>		
22.0	PREP-GENERAL	Préparation du matériel	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Sceller le Foam Core N° DKC134-0021 selon IG 0105.		
	Date: <u>25-06-13</u> Sceau: <u>RL</u>		
23.0	AAC1611	Polybond B46F	
Comment	Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s) Polybond B46F N° de Lot: <u>1-38189-1</u>		
24.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Positionner et coller le Foam Core N° DKC134-0021 selon IF134-0011.		
	Date: <u>26/06/13</u> Sceau:  <u>4460 R.L</u>		

Feuille de Procédé












Client:	DART US DART AEROSPACE	Nom Dessin:	UTILITY POD BASE
Numéro Job:	51515	Numéro	DKC134-0075
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
25.0	BAGGING	Faire le bagging sur la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Faire la poche à vide selon IG 0012.		
	Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.		
	Heure début Curing: <u>1:30</u> Heure Fin Curing: <u>3:00</u>		
	Date: <u>26/06/13</u> Sceau:  <u>R.L. 4460</u>		
26.0	DECOUPE	Découpe manuelle des pièces	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Faire la découpe manuelle du foamcore selon IF134-0011 point 8.5.		
	Date: <u>26/06/13</u> Sceau:  <u>4460 R.L.</u>		
27.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s)		
	Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-41488-1</u>		
28.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0845 GALLON(s)/Unit Total: 0.0845 GALLON(s)		
	Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
29.0	LAMINAGE	Faire le laminage	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Faire le laminage des derniers tissus selon IF134-0011.		
	Date: <u>28/06/13</u> Sceau:  <u>4460 R.L. 4102 NT</u>		
30.0	BAGGING	Faire le bagging sur la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Faire la poche à vide selon IG 0012.		
	Laisser sécher pendant 4 heures minimum.		
	Heure début Curing: <u>10:30</u> Heure Fin Curing: <u>8:00</u> <u>4102 NT</u>		

Date: Mercredi, 2013-04-24 08:15:56
Utilisateur: Mario Chantal

Feuille de Procédé

Cliënt: DART US DART AEROSPACE	Nom Dessin: UTILITY POD BASE	
Numéro Job: 51515	Numéro: DKC134-0075	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
Date: <u>2/06/13</u> Sceau:  <u>4460 R.L</u>		
31.0	AAC1615	D3001-1 Doubler (Pod Base D2002-3)
Comment	Qty.: 3 UNITE(s)/Unit Total : 3 UNITE(s) D3001-1 Doubler (Pod Base D2002-3) N° de Lot: <u>1-40726-2</u>	
32.0	AAC0102	Colle Araldite N° 2012 (50ml)
Comment	Qty.: 0.50 UNITE(s)/Unit Total : 0.50 UNITE(s) Colle Araldite N° 2012 (50ml) N° de Lot: <u>1-41394-1</u>	
33.0	ASSEMBLAGE	Assemblage mécanique
		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Coller les trois doublers N° D3001-1 selon IF134-0011. Faire trois petites poches à vide selon IG 0012. Laisser sécher pendant 4 heures minimum. Heure début Curing: <u>4:20 P.M</u> Heure Fin Curing: <u>8:00 A.M</u> Date: <u>2/07/13</u> Sceau:  <u>4460 R.L.</u>	
34.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler
Comment	Qty.: 0.030 GALLON(s)/Unit Total : 0.030 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: <u>1-40986-1</u>	
35.0	FINITION	Finition Générale
		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Retirer les trois poches à vide et faire un joint tout autour des trois doublers à l'aide du "Filler" P15-3 et laisser sécher. Date: <u>3/07/13</u> Sceau: 	
36.0	AAC1680	D3048-1 Doubler
Comment	Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) D3048-1 Doubler N° de Lot: <u>1-40726-1</u>	
37.0	LAMINAGE	Faire le laminage
		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le laminage des tissus pour épaissir et installer le grand doubler selon IF134-0011.	

Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: UTILITY POD BASE	
Numéro Job: 51515		Numéro: DKC134-0075	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
	Date: 3/07/13 Sceau: 	4460 R.L.	
38.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Comment	Qty.: 0.060 GALLON(s)/Unit Total : 0.060 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-40986-1		
39.0	FINITION	Finition Générale	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la finition de l'intérieur selon IG 0043. Vérifier la surface intérieure du Pod et injecter à l'aide d'une seringue munie d'une aiguille de la résine aux endroits où il y a des bulles d'air. Corriger les imperfections de surface à l'aide du "Filler" P15-3. Laisser sécher jusqu'au lendemain. Date: 4/07/13 Sceau: 		
40.0	DÉMOULAGE	Démoulage de la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le démoulage du Utility Pod Base en faisant bien attention de ne pas endommager la pièce. Autocontrôle de la qualité du laminage en frappant légèrement sur toute la surface du Pod à l'aide d'un manche de tournevis. Date: 4/07/13 Sceau: 		
41.0	TRIMAGE	Trimage	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le trimage selon IF134-0012. Date: 4/07/13 Sceau: 		

Date: Mercredi, 2013-04-24 08:15:56
Utilisateur: Mario Chantal

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 51515

Nom Dessin: UTILITY POD BASE
Numéro: DKC134-0075

Numéro Job:



Séq.:

Machine ou Opération:

Description :

50.0

INSPEC FINAL

Inspection finale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: 15.7.13 Sceau:



51.0

EMBAL / ENTREPO

Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057.

Date: 11 juillet 13 Sceau: 4451